

Date: Wednesday, 5/31/2006 7:33:45 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FOLDING STEP WELDMENT LH
<b>Job Number</b> :	27272		
<b>Estimate Number</b> :	10463		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D3388041
<b>This Issue</b> :	5/31/2006	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3388 REV A
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	27268	<b>Drawing Revision</b> :	A
		<b>Material</b> :	N/A
<b>Written By</b> :	<i>[Signature]</i>	<b>Due Date</b> :	6/30/2006
<b>Checked &amp; Approved By</b> :	<i>[Signature]</i> 06.05.31	<b>Qty:</b>	5 Um: Each
<b>Comment</b> :	Est. B 05.06.10 Added Step 11 KJ/JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D2622120C	Extrusion
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
 D2622-120C extrusion 8  
 Batch: *B 27077*

*FF 06-07-11 5*

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1  
 1-Cut D2622-120C extrusion 85.15" long as per Dwg D3388  
 2-Deburr and bevel ends for welding

*FF 06-07-11 5*

*FF 06-07-11 5*

3.0	D2734	206 Step Endplate
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 206 Step Endplate  
 Pick:  

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>327281=3</i>

*324402=3*

*FF 06-07-11 5*

4.0	D33871	Arm
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 Arm  
 Pick:  

Qty	Part Number	Description	Batch
2	D3387-1	Arm	<i>327104</i>

*FF 06-07-11 5*

W/O: 1		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-07-26	6.1	QC 3 Inspect chemical conversion coat.	[Signature]	06-07-26	5	[Signature]	[Signature]	
	6.2	Inspect for Foreign objects, Weld last end cap & grind flush. Al Rod B <sup>th</sup>	[Signature]	06-07-27	5	[Signature]	06-07-26	
	6.3	QC 5/9 inspect work to step: welds.	[Signature]	06-08-02		[Signature]		
06-07-26	4	Add these steps. Perim-Change				[Signature]	[Signature]	
	6.4	Alodine end cap as per QS1005 4.1.		06-08-04		[Signature]	06-07-26	

NCR: <u>27272</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-08-01	5.0	2 steps have debris inside. Not big.	<i>[Signature]</i>	drill hole as necessary and remove all foreign objects. Fill hole with weld as per QS1005 and grind flush.	<i>[Signature]</i> 06-08-02	<i>[Signature]</i> 06-08-02	<i>[Signature]</i> 06-08-02	06-08-01

Part No: D3388-041 PAR #: N/A Fault Category: Peri - Lg. FAS NCR: Yes No DQA:    Date: 06-08-24

NOTE: Date & initial all entries QA: N/C Closed:    Date: 06-08-24

Date: Wednesday, 5/31/2006 7:33:45 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOLDING STEP WELDMENT LH

Job Number: 27272

Part Number: D3388041

Job Number: 

Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms and end caps as per Dwg D3388.

Inspect for foreign objects as per QSI 024. Dwg Rev: A

Grind end cap welds flush

*Handwritten:* J.E. 06.07.20  
d.e. 06.07.20  
FF 06.07.20

*Handwritten:* PTO

*Handwritten:* 5  
5  
5

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Handwritten:* SAD 06.07.25

*Handwritten:* 5

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*Handwritten:* a.m 06-08-08

*Handwritten:* PTO

*Handwritten:* on previous page

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3388 and QSI 005 4.4

*Handwritten:* SC 06/08/08

*Handwritten:* 5

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect Powder Coat and Wing Walk

*Handwritten:* a.m 06-08-09

*Handwritten:* 5

10.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Spacer

Pick:

Qty

Part Number

Description

Batch

1

D2808

Spacer

*Handwritten:* B27564

*Handwritten:* SAD 08.08.15

*Handwritten:* 5

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press spacer into D3387-1 arm as per Dwg D3387

*Handwritten:* SAD

*Handwritten:* 08.08.15

*Handwritten:* 5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-07-20	S.1	Inspect Level 5/9 QC S/9 Done by: J. 06-07-21 / 11/06/07/21 (S)						
06-07-20	S.1	Add Previous step to estimate	E	06-07-20				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 5/31/2006 7:33:46 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOLDING STEP WELDMENT LH

Job Number: 27272

Part Number: D3388041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP

06/08/15

5

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G.A.

N/A

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.08.24

Job Completion



u 06.08.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

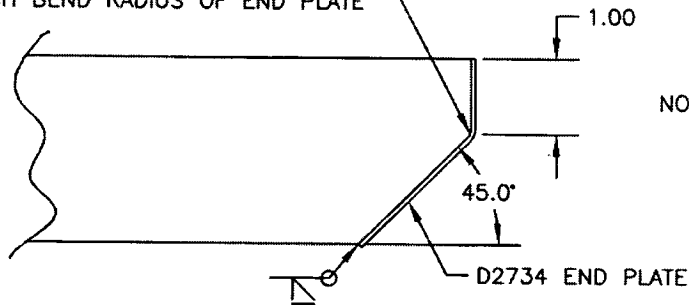
**DART**

RELEASED

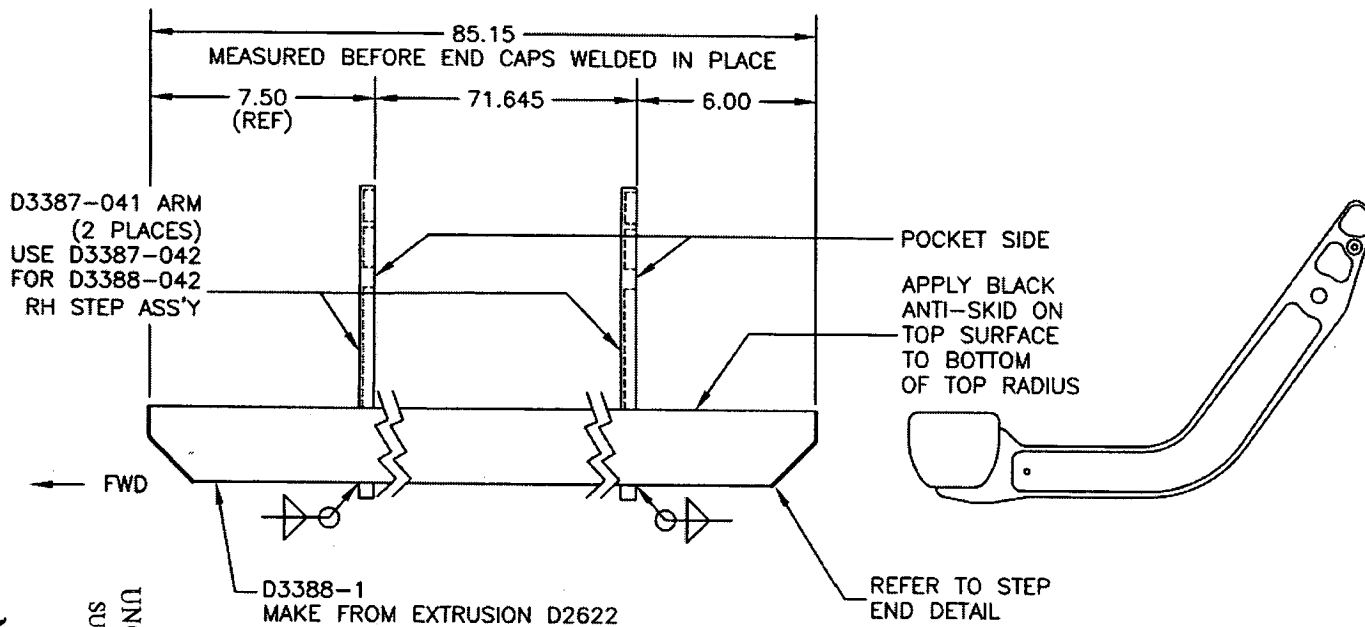
05-03-11

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL  
NOT TO SCALE



**D3388-041 LH STEP ASSEMBLY (SHOWN)**  
**D3388-042 RH STEP ASSEMBLY (OPPOSITE)**

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDEX (4.3.5.6)  
OR BLACK SANDEX (4.3.5.7) OR GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

**DART AEROSPACE LTD**  
HAMKESBURY, ONTARIO, CANADA

REV. A

SHEET 1 OF 1

SCALE

NTS

STEP WELDMENT

DATE  
05.01.20

A

05.01.20

NEW ISSUE